











Insert Z4, concentric Chipbreaker DI 22.35

A08-350

A circular chipbreaker is ground concentric with respect to the concave radius of the chamfering Insert. In addition a k-land operation is done along the concave radius. All operations are executed in one setup using the TTC clamping system.



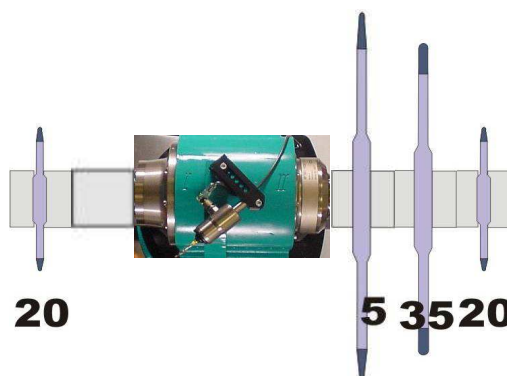
1. Cycletime for Production

Tool specifications						
Concave Radius 5 mm, BxH 22.35x22.35						
Material CARBIDE						
Operations						
Feed [mm/Min]	2000	200	35	60	90	9000
Power [kW]		1	1	2	1	1
Cutting feed [m/s]		18	22	22	22	
Used wheels						
Grinding time [s]	5	62	117	95	85	18
Total cycle time	6 Min 23					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

20	14EE1 Ø40 D64
35	14F1 Ø150 D76
5	14EE1 Ø200 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 bar
 Software: Quinto 5

responsible engineer: OP,31.10.08

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